Quality Control

| Work Order April-11-13 2:13: | | 601 | | *996 | 301 | * | | | | | | Page 1 |
|---|--------------------|--|-----------------------------|---|------------|--------------------------|------------|--------------|---------------|------------------|------------------|-----------------|
| Revision ID: | D3121-21 | | A | Accept | */ | 1900 | 040 | 100 |)* s | Setup Star | i Zi | S1* S2* |
| Start Date: 4 Required Date: 4 Reference: | h/22/13 h/22/13 | Start Qty: 30.00 Req'd Qty: 30.00 | *30* *30* | | | Cust Item I Customer: | D: | | | | | |
| Approvals: | Process Pla | an: | Date: 13-04-12 | Tooling: | | Da | ate: | | | Run Stai Stoj | 1/1 | R1* |
| 1 | QC: | | Date: | SPC (Y/N): | | D: | ate: | | | 50 | *N | R2* |
| Sequence ID/ Work Center ID | | Operation Description | | Set Up/ Run Hours | | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Rev | vision Nbr | | *** | | - | | | | | | |
| D3121 | Rev | / E | | | | | | | | | | |
| *100 *100* Hardinge Hardinge CNC Lathe | Small | Hardinge CNC LATHE Memo 1-Turn D31 0.005" to 0. | 21-21 2-Identify as D3121-2 | 0.00 0.00 213-Deburr break all sh | narp edges | PO 13 | 3/04/17 | | 30 | Ø | | · |
| *110 *110* QC Quality Control | | QC2- Inspect parts off m | nachine FAI/FAIB | 0.00 | 90 | 13/01 | 117 | | 30 | Ø | | |
| | • | • | | | | | | | | | | |
| *120 | | QC8- Inspect parts - sec | ond check | 0.00 | be | a Blor | 1/20 | | 30 | Ø | | 08 08 9-8 |
| QC | | Memo | • | 0.00 | | , | • | | | ţ | | |

| | | | | | | | | | | DQA: | Date | : |
|---------------|-------------|----------------|-----------|----------|----------------------------|----------|---|---------------------------------------|----|--------------|---------------|--------------------|
| NCR: | Yes / No | | | | WORK ORDER NON- | CON | FORM | AANCE / UPDATE | | | | |
| | | | | | | | | | | QA Closed: | Date | · · |
| | | | | | DISPOSITION | | | AGAINST (| DE | PARTMENT/ | PROCESS | |
| Work Ord | er: | | | | Rework | 1 | | Skid-tube Crosstube | | | Water Jet | Engineering |
| Dart I | No. | | | | Scrap | 1 1 | | Machining Small Fab | | Proc | d. Eng. Coor. | Quality |
| Part I | NO | | | | Use-as-is | 1 | | noforming Finishing | | | e/Packaging | Other |
| NCR I | Vo | | | | Work Order Update | 1 | | Large Fab Composite | | , | Supplier | - |
| 110111 | ··· | | | | | - | | | | | | |
| Root | | | | Descri | ption of work order update | Ir | itial | Action | | Sign & | | |
| Cause | Date | Step | Qty | | or Non-conformance | Chi | ef Eng | Description | | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | • | |
| Operator | | | | | | | | | | | | |
| Material | | | | | | ł | | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | Ì | | | | | | |
| Supplier | Ш | | | | | ļ | | | | | | |
| Training | | | | | • | | | | | | | |
| Unapproved | <u> </u> | | <u> </u> | <u>L</u> | | 01117 | CATE | CORV | | | | |
| | | | | | General | AUL | CATE | GURY | | | | |
| Landi | ing Gear | | | | Bend | | Grain | ſ | _ | Ovalized | ۲ | Pressure/Forced |
| | Bending | : Not Conce | ntric to | o/s | BOM/Route | \vdash | Hardwa | ro | | Over/Under | tolerance | Temperature/Cure |
| | Cracks | NOT CORCE | HILLIC TO | " - | Broken/Damaged | \vdash | | ion Incomplete | | Part Incorre | | Weld |
| | ${f oxdot}$ | I/Crimped | | - | Burrs | | | ions Incomplete/Unclear | | Part Lost/Mi | <u> </u> | Wrong Stock Pulled |
| | Cuffs | i) Ci ii iped | • | <u> </u> | Contamination | - | | · · · · · · · · · · · · · · · · · · · | | Part Moved | | |
| | Heat Tre | eat | | - | Countersink | \vdash | Maintenance Part Moved Mislabeled Positioned Wrong | | | | Vrong | |

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| Work Orde | | 601 | | *996 | SO1* | | | | | | | Page 2 |
|---|--------------------|--|---------------------------|------------------------------|-----------------------|-------|--------------|--------------|-------|---------------|--------|-------------|
| Item ID: Revision ID: Item Name: | D3121-21 Bolt | | | Accept | *N900 | 040 | 100 |)* | Setup | Start Stop | *NS | 11* 12* |
| Start Date: Required Date: Reference: | 4/22/13 4/22/13 | Start Qty: 30.00 Req'd Qty: 30.00 | *30* *30* | | Cust Item Customer: | ID: | | | | | | |
| Approvals: | Process Pla | n: | Date: | Tooling: SPC (Y/N): | | ate: | | | Run | Start Stop | "INH | ?1* ?2* |
| Sequence ID/ Work Center II 130 *120* Packaging Packaging | D | Operation Description Identify as per dwg & Stoc | k Location: <u>87</u> 239 | Set Up/ Run Hours 0.00 | Tool ID | Tool# | Plan Code | Accep Qty | Qt | | • | Insp. Stamp |
| 140 *140* QC Quality Control | | QC21- Final Inspection - V | Vork Order Release | 0.00 | | | | | | 3/4 | 1/23/2 | 9 |

\$ 13.04.23

| | | | | | | | | | | • | DQA: | Date: | |
|--------------------------------|-------|------------|------------|----------|--------|--|-----|---------|------------------------|-------------|---|---------------------------|--------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON-C | O | NFORM | MANCE / UPDA | TE | | | |
| | | | | | | | | | | | QA Closed: | Date: | 71.477. |
| Work Ord | or: | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | PROCESS | |
| Work Order: Part No. NCR No. | | | | | | Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite | | | Small Fab Finishing | | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other | |
| Root | | | | | Descri | ption of work order update | 1 | nitial | Action | n | Sign & | | |
| Cause | | Date | Step | Qty | C | or Non-conformance | Ch | ief Eng | Descript | tion | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Setup | | | 1 | | | | | | | | | | |
| Other | | | ļ | | | | | | | | | | |
| Process | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | _ | | | | | | | | | | | | |
| Unapproved | | <u> </u> | | | | | | | | | <u> </u> | | |
| | | | | | | F | AUL | T CATE | GORY | | | | |
| Landi | ing (| 1 | | | _ | General | | 1 | | | 1 | _ | ٦ |
| | _ | Bending | | | | Bend | _ | Grain | | | Ovalized | | Pressure/Forced |
| | | Centre No | ot Concer | ntric to | O/S | BOM/Route | | Hardwa | | ļ | Over/Under | . — | Temperature/Cure |
| | | Cracks | | | | Broken/Damaged | | | on Incomplete | | Part Incorre | | Weld |
| | | Crushed/ | Crimped. | | | Burrs | L_ | ł | ions Incomplete/Und | clear | Part Lost/M | issing | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | | Mainte | enance | | Part Moved | | |
| | | Heat Trea | it | | | Countersink | L | Mislabe | eled | | Positioned V | Vrong | |
| | | Inspection | n Strin in | Tuhe | | Cut Too Short | 1 | Misread | 1 | | Power Loss/ | Surge | Other |

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio **Picklist Print**

April-11-13 2:13:48 PM

Work Order ID:

99601

Parent Item:

D3121-21

Parent Item Name:

Bolt

Start Date: 4/22/13

Required Date: 4/22/13

Page 1

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP A04.02.09New issueKJ/DS

IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M303H0.500 303 HEX BAR .500 | | Purchased | No | | | 110 | f | 22.7000 | 0.0417 | 1.251 | Po | 13/0 | 4/17 |

LocationLoc OtyLoc CodeMAT01822.7

124761 22.7

1,265

| NCR: | Yes | / No | | | | WORK ORDER NON- | COI | NFORM | MANCE / UPD | ATE | QA Closed: | Date: | |
|---|---------|---|--------------------------------------|---------|--------|--|------|--|--|---|--|------------------|--|
| Work Orde | er: | | | <u></u> | | DISPOSITION | | | | AGAINST D | EPARTMENT, | | gay kigan dikitida kalamini ka madanya mana tayayakan sasara |
| | Part No | | | | | Rework Skid-tube Crosstube Machining Small Fab Use-as-is Thermoforming Finishing Composite | | | - | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other | | |
| Root | | | | | Descri | ption of work order update | | Initial | Acti | on | Sign & | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Ch | nief Eng | Descri | ption | Date | Verification | QC Inspector |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | LT CATE | CORV | | | • | |
| Landi | na G | | | | | General | FAUL | LICATE | GORT | | | | |
| Landi | | Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio | Crimped. It n Strip in Bend | Tube | | Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes | | Instruct Mainte Mislabe Misread Offset | on Incomplete ions Incomplete/U enance eled | nclear | Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/ | ct sissing Vrong | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other |
| | | Torque W | aves in E | xtrusio | n | Drawing | | Out of 0 | Calibration | | | | |

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| DART AEROSPACE LTD | Work Order: | 99601 |
|------------------------------|--------------|-------------|
| Description: Bolt | Part Number: | D3121-21 |
| Inspection Dwg: D3121 Rev: E | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | • • | | | |
|----------------------|----------------------------|---------------------|--------|---------|----------------------|----------|--|--|
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments | | |
| 0.375 | +/-0.010 | .375 | | | VERN | 140-01 | | |
| 0.050 - 0.060 | N/A | .054 | | | VERN | 140-01 | | |
| 0.080 | +/-0.010 | .085 | / | | VERO | P40-01 | | |
| 10-32UNF3A | N/A | 10-32 UNF 31 | | | Mic | PHO-02 | | |
| Major Diameter | Max: 0.190 Min: 0.184 | . 188 | | | ķ r | 11 | | |
| Over wire | Max: 0.2146 Min: 0.2123 | . 2139 | | | А | 4 | | |
| | | | | | | | | |
| | | | | | | | | |
| 100 | | | | | | | | |
| | | | | <u></u> | | | | |
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| | | | | | | j. | | |
| | - 41-11 | | | | | | | |
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| | | | ĺ | | | | | |

| Measured by: | 10 | Audited by: | D. 9 08 | Prototype Approval: | N/A |
|--------------|----------|-------------|----------|---------------------|-----|
| Date: | 13/04/17 | Date: | 13/04/20 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------|------------|----------|
| Α | 04.02.27 | New Issue | KJ/RF | |
| В | 06.03.09 | Dwg Rev. updated | KJ/JLM | |
| С | 06.06.14 | Dwg Rev. updated | KJ/JLM | |
| D | 08.01.16 | Dwg Rev. updated | KJ/EC/DD, | |
| E | 08.07.23 | Dimensions updated | KJ/DD | 13/ |



| DESIG | # | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
|-------|------|----------|---|
| CHEC | KED | APPROVED | DRAWING NO. REV. E |
| | 911 | | D3121 SHEET 1 OF 10 |
| DATE | | - | TITLE SCALE |
| 07.1 | 1.07 | | BRACKET ASSEMBLY 1:2 |
| Α | | 02.04.15 | NEW ISSUE |
| В | | 03.01.16 | ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146 |
| ·C | | 04.02.17 | ADD CLEARANCE; USE -241 BEARING |
| D | | 06.05.17 | D3121-25 CAP WAS 1.024, NOW 1.000 |
| | | | |



D3121-21 BOLT (1) D3121-241 BEARING ASSEMBLY (1)

Εl

D3121-11 BRACKET

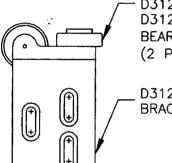
D3121-041 BRACKET ASSEMBLY

07.11.07

(REPLACES PREMIER P/N B30-23000-33)

99601 \$13-04-12

ADD TOLERANCE TO 0.032 (DETAIL B)



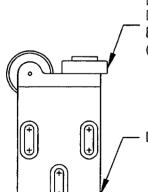
(

D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)
(2 PLACES)

D3121-13/-14 BRACKET

D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-21 BOLT (1) D3121-241 BEARING ASSEMBLY (1) (2 PLACES)

D3121-15/-16 BRACKET

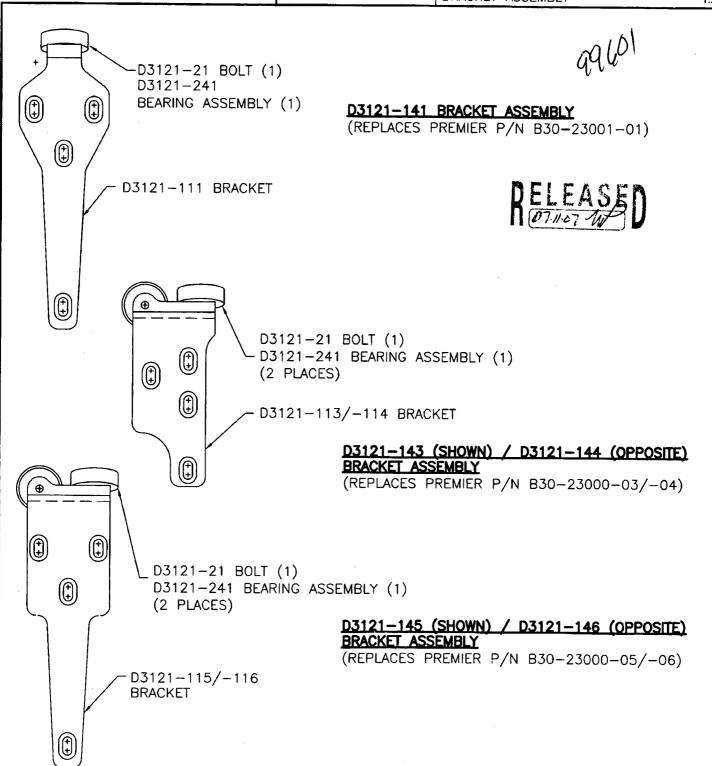
D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)

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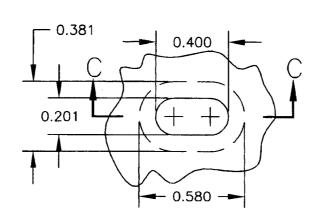
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| CHECKED | APPROVED | DRAWING NO. | REV. E |
| # | | D3121 | SHEET 2 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |

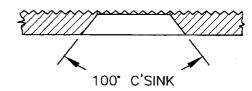




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| Ì | # | -# | D3121 | SHEET 3 OF 10 |
| Ī | DATE | | TITLE | SCALE |
| | 07.11.07 | | BRACKET ASSEMBLY | 1:1 |

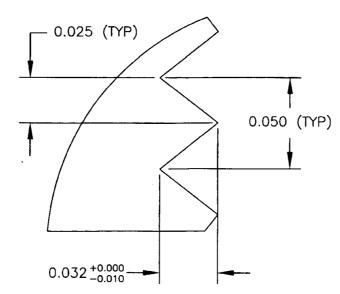
DETAIL A: SLOT DETAIL SCALE 2:1 VIEW ROTATED





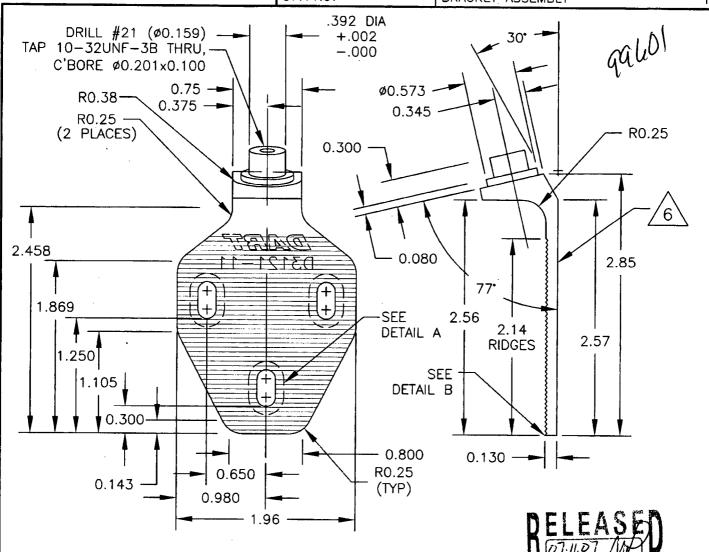
SECTION C-C

DETAIL B: RIDGE DETAIL PARTIAL SECTION SCALE 1:20





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| CHECKED | APPROVED. | DRAWING NO. | REV. E SHEET 4 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:1 |

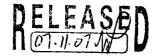


D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



| DESIGN # | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
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| CHECKED | APPROVED | DRAWING NO. | REV. E |
| 4 | | D3121 | SHEET 5 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |



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DAY3T

D3121-13

1.220 ----- 1.800 -

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2.63

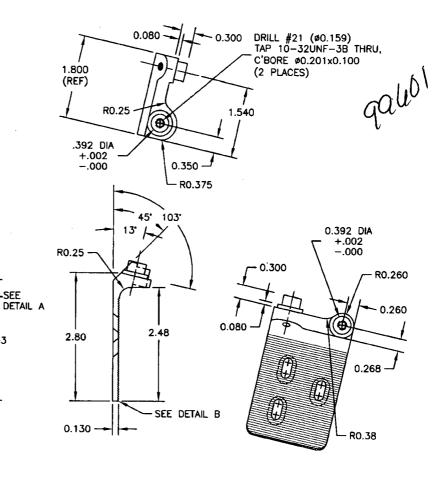
<u></u>

0.400 -

1.280

0.960

0.330



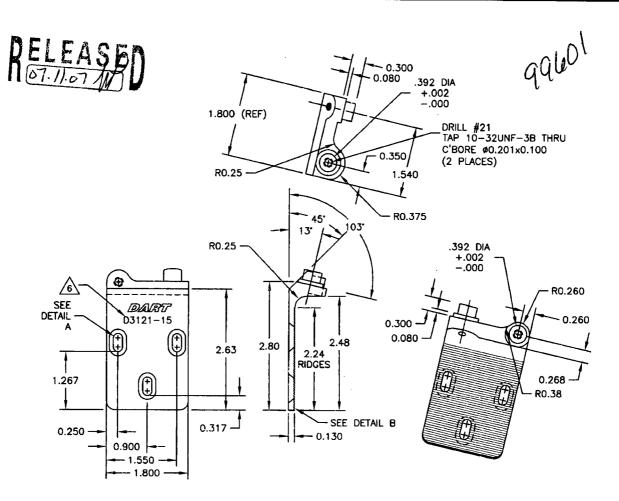
D3121-13 BRACKET (SHOWN) D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE STRENGTH = 150 ksi
 MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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|----------|----------|--|---------------|
| CHECKED | APPROVED | DRAWING NO. | REV. E |
| 97 | - All | D3121 | SHEET 6 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |



D3121-15 BRACKET (SHOWN) D3121-16 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi

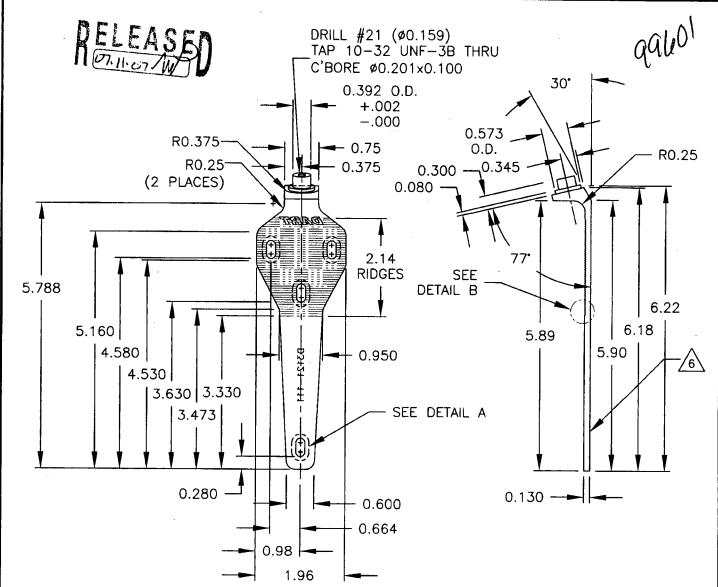
MIN YIELD TENSILE = 100 ksi

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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| CHECKED | APPROVED | DRAWING NO. D3121 | REV. E SHEET 7 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

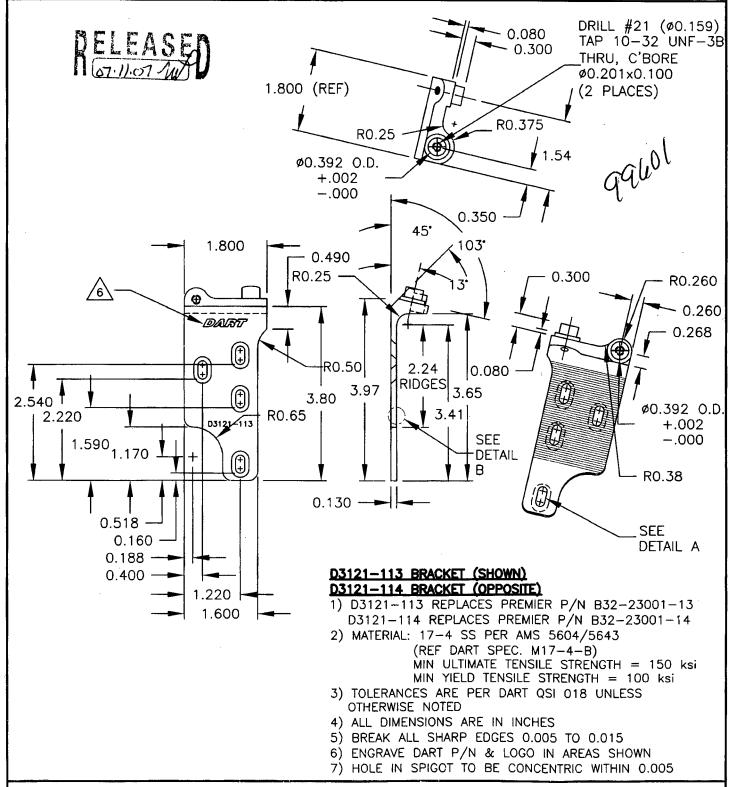
MIN ULTIMATE TENSILE = 150 ksi

MIN YIELD TENSILE = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



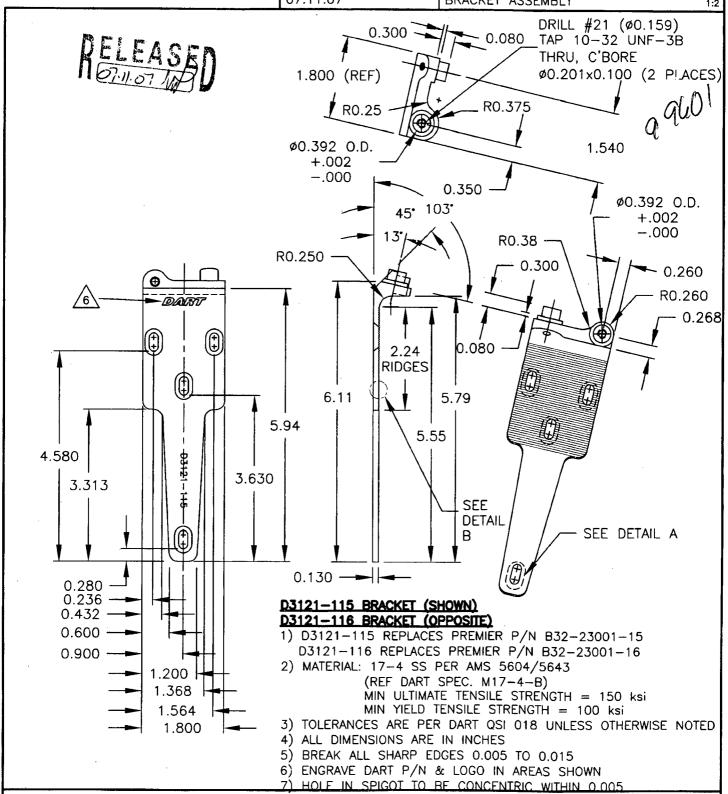
| DESIGN DRAWN BY | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
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| CHECKED | APPROVED | DRAWING NO. | REV. E |
| 911 | | D3121 | SHEET 8 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |



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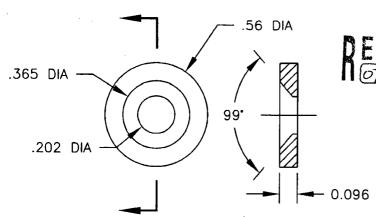
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| CHECKED | APPROVED, | DRAWING NO. | REV. E |
| 94 | - | D3121 | SHEET 9 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |



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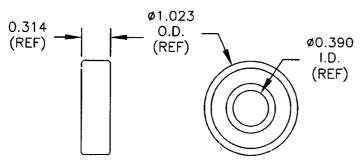


| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|----------|----------|--|----------------|
| CHECKED | APPROVED | DRAWING NO. | REV. £ |
| 4 | - | D3121 | SHEET 10 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBL | <u>Y</u> 1:1 |



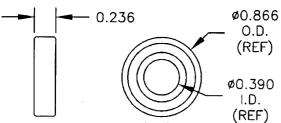
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- ALL DIMENSIONS ARE IN INCHES

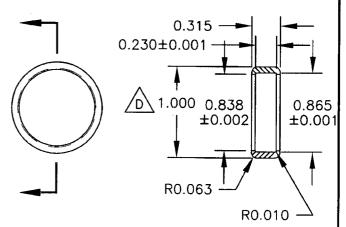
0.375 -TAP 10-32 UNF-3A DELEAS 0.080

D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

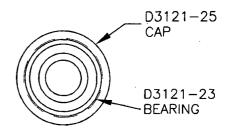
0.050 TO 0.060

- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25
 - (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)